

**CLAIMS**

**WHAT IS CLAIMED IS :**

- 5 1. Fibers comprising a copolymer of poly(ethylene terephthalate) and poly(ethylene naphthalate), (PETN).
- 10 2. PETN fibers according to claim 1, wherein the fibers comprise in the range of 1 mole% to 30 mole % naphthalene dicarboxylate and the remainder of the dicarboxylate moieties as terephthalate.
- 15 3. PETN fibers according to claim 1, wherein the fibers have a denier per filament in the range of 1 – 30.
4. PETN fibers according to claim 1, wherein the fibers have a round, scalloped oval, hollow, trilobal hollow or four-hole cross section.
- 20 5. Clusters comprising PETN fibers according to claim 1.
6. Clusters comprising a blend of dry PETN fibers according to claim 1 and slickened PETN fibers according to claim 1.
- 25 7. A batt comprising PETN fibers according to claim 1 in either a cross-lapped or vertical folded configuration.
8. The batt according to claim 7, having an initial bulk (BL1) in the range of 4.2 to 5.1.
- 30 9. The batt according to claim 7, having a residual bulk (BL2) in the range of 0.47 to 0.50.
10. A process for making fibers comprising a copolymer of polyethylene terephthalate and poly(ethylene naphthalate) (PETN), including reacting dimethyl terephthalate (DMT) and naphthalene dicarboxylate (NDC) with ethylene glycol.